

Work Order ID 160522-1

160522

Page 1

Wednesday, May 03, 2017 7:34:17 AM

Item ID: D2423

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Extrusion

Start Date: 5/1/2017 Start Qty: 352.00

352

Cust Item ID:

Required Date: 5/24/2017 Req'd Qty: 352.00

352

Customer:

Reference:

DAS

13

9-89

Approvals:

Process Plan:

Date:

MAY 03 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2423

Rev B1

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

36272

Manufacture as per Dwg

Possible Supplier: SIGNATURE ALUMINUM

Material release note is required

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

352

MAY 10 2017

DAS

13

9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

7.04

Packaging

336F 5017-6-15

Work Order ID 160522

Monday, May 01, 2017 10:22:26 AM

160522

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Item ID: D2423 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Extrusion
Start Date: 5/1/2017 Start Qty: 352.00 ***352*** Cust Item ID:
Required Date: 5/24/2017 Req'd Qty: 352.00 ***352*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- All purchased or subcontracted products	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>meter</u>	0.00							
130									
Packaging	Memo	3.52							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	35.20							
Quality Control									

DAS
21
9-89 JUN 22 2017

Picklist Print

Monday, May 01, 2017 10:22:26 AM

Page 1

Work Order ID: 160522

160522

Parent Item: D2423

D2423

Parent Item Name: Lug Extrusion

Start Date: 5/1/2017

Required Date: 5/24/2017

Start Qty: 352.00

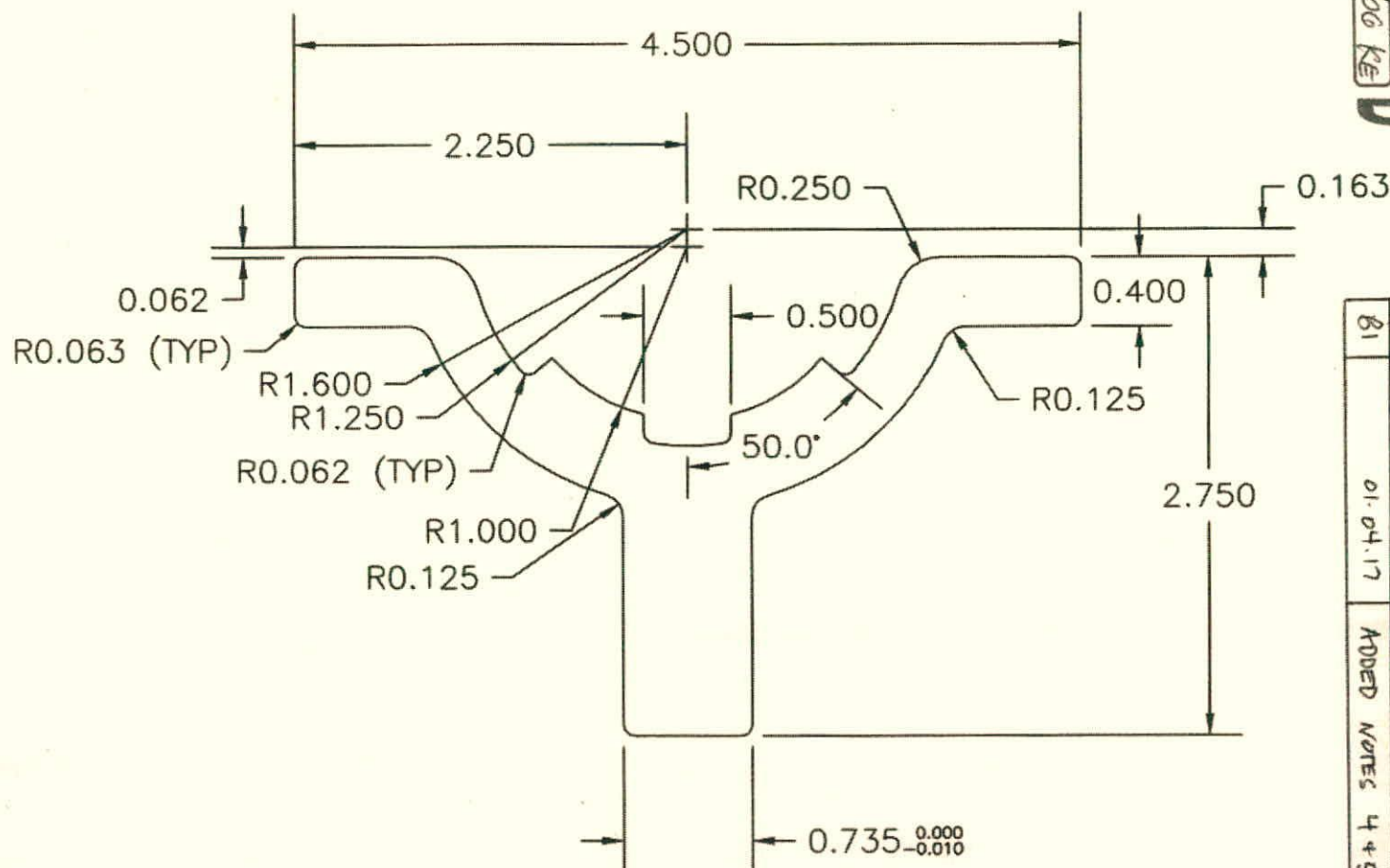
Required Qty: 352.00

Comments: IPP G04.09.02Part Number D2423-108 changed to D2423KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423P *D2423P* Lug Extrusion		Purchased	No			100	f	0.0000	1	352			
										**	336F Sp 17-6-75		

DART**RELEASED**
98/08/06 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
LE	KE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	KE	D2423	
DATE	TITLE	SCALE	
98.08.04	LUG EXTRUSION	1:1	
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4+5	



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARADON INDALOX DIE # MS-18866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36272

Purchase Order Date 5/10/2017

PO Print Date 5/10/2017

Page Number 1 of 2

Order From : VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MAY 10 2017

Contact Name
Vendor Phone 905-427-6550

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
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1	D2423P	Lug Extrusion ✓	6/7/2017		352.00	\$9.12	\$3,210.33
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NOTE: MATERIAL MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG)
B148835

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS

336 f

Line Total: \$3,210.33

2	71401-45	procurement quality clauses ✓	6/7/2017		1.00	\$0.00	\$0.00
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Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

PO Instructions: quote no. 05092017-010

Note:

5/10/2017



1850 Cléments Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.comSIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

ERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCEPACKING LIST DATE / DATE DU
06-14-17PACKING LIST NUMBER / N° DE
032276SALES ORDER NUMBER / N° DE COM
128022

CUSTOMER ID / ID DU CLIENT 46024		ORDER DATE / DE LA COM 05/10/17		CUSTOMER PO NUMBER / CLIENT PO Nombre PO36272		JOB / FICHIER		FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU		SALES REP / REP. DES VENTES R. BLAIS	
BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 032276		CARRIER / TRANSPORTEUR MCGILLION		SALES MAN / VENDEUR 042		CREDIT REP / REP DU CRÉDIT		SALES REP / REP. DES VENTES R. BLAIS		CUST SERVICE REP / REP. SERVICE CLIENTELE S1S	
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,387	LB		DAA-5-2	6061 T6		1	1,268	1,246	LB	
	629	KG		D2423P	96.0000 IN			575	565	KG	
Y	45	PC			Cut(+):0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			42	PC	
							881975 / 372840	1	1,268	1,246	42 PC

SP17-615

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the following standards: set of 1000 as specified. Orders accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1 of 1

DATE OF DELIVERY

DRIVER

1	1,268	1,246	LB
	575	565	KG
		42	PC
TOTALS			

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
06/11/2017	5434557	128022	1
Cust PO	B/L No	Lot	Date
PO36272	032276	881975	06/14/17

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	1,268 LBS		
Net Qty	1,246 LBS 42 PCS 1 PKGS		
Specification			Die Desc
AMS QQA 200/8 + ASTM B221			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
311.1 / 45.1	282.1 / 40.9	15.4	N/A	95

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.59	0.33	0.21	0.07	0.88	0.07	0.10	0.02	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

